

Work Order ID 61077

Thursday, August 05, 2010 11:35:20 AM



Page 1

Item ID: D3912-041

Accept



Setup Start



Revision ID:

Item Name: Eyebolt Receiver Assembly

Stop



Start Date: 8/5/2010 Start Qty: 2.00



Cust Item ID:

Required Date: 8/12/2010 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan: *MF* Date: *10-8-05* Tooling:

Date:

Run Start



QC: Date: SPC (Y/N):

Date:

Stop



| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

| Draw Nbr | Revision Nbr |
|----------|--------------|
| D3912 | B |

100 Pick Kit 0.00



Packaging Memo 0.00

Packaging

110 0.00



Small Fab Memo 0.00

Small Fab

1-Assemble D3912-1/-3/-5 and install rivets as per dwg
TRIM RIVETS 1.250" LONG

2- Install helical, spring plunger and spring pin lanyard assy as per dwg

120 QC5- Inspect part completeness to step on W/O 0.00



QC Memo 0.00

Quality Control

8/10/05/10

8/5/08/10 (2)

8/5/08/10

(2)

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

170

Identify as per dwg & Stock Location: **507**

0.00



Packaging

Memo

0.00

Packaging

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/8/10 **MF**

10/08/10 **MF**

10-8-10

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NOTE: Date & initial all entries

Picklist Print

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Page 1

Work Order ID: 61077

Parent Item: D3912-041

Parent Item Name: Eyebolt Receiver Assembly

Start Date: 8/5/2010

Required Date: 8/12/2010

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP RevA: new issue DD 09.11.18 verified by:EC IPP Rev:B
10.06.10 memo in seq110 ***IF PLUNGER GOES IN TO DEEP, INSTALL A
WASHER (AN960C516L) IF NECESSARY BETWEEN PLUNGER AND
D3912-1. YOU MAY HAVE TO ENLARGE WASHER HOLE FOR IT TO
FIT*** DD verf:JLM IPP REV:C AS PER REV B 10-08-05 JLM
VERIFIED:DD

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-----------------|--------------|---------------|----------------|--------|
| D3912-1 Eyebolt | | Manufactured | No | | | 100 | Each | 6.0000 | 1 | 2 | | 8/10/08/09 | |
| | | | | <u>Location</u> | | | | <u>Loc Qty</u> | <u>Loc Code</u> | | | | |
| | | | | FG096 | 59441 | | | 6 | | | | | |
| | | | | | | | | 6 | | | | | |
| D3912-3 Eyebolt Block | | Manufactured | No | | | 100 | Each | 10.0000 | 2 | 4 | | 8/10/08/09 | |
| | | | | <u>Location</u> | | | | <u>Loc Qty</u> | <u>Loc Code</u> | | | | |
| | | | | ST096 | 59430 | | | 10 | | | | | |
| | | | | | | | | 10 | | | | | |
| D3912-5 Eyebolt Plate | | Manufactured | No | | | 100 | Each | 1.0000 | 2 | 4 | | 8/10/08/09 | |
| | | | | <u>Location</u> | | | | <u>Loc Qty</u> | <u>Loc Code</u> | | | | |
| | | | | ST096 | 58782 | | | 1 | | | | | |
| | | | | | | | | 1 | | | | | |

B61078 (34)

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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NOTE: Date & initial all entries

Picklist Print

Thursday, August 05, 2010 11:35:20 AM

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Work Order ID: 61077

Parent Item: D3912-041

Parent Item Name: Eyebolt Receiver Assembly

D3801-1 Manufactured No

Hand Retractable Spring Plunger



Start Date: 8/5/2010

Required Date: 8/12/2010

Start Qty: 2.00

Required Qty: 2.00

Each

18.0000

Location

Loc Qty

Loc Code

ST088

18

40736

2

56905

16

MS20615-4M20

Purchased

No

100

Each

282.0000

RIVET

Location

Loc Qty

Loc Code

ST323

282

114808

112

115054

170

MS21209-F615

Purchased

No

Each

99.0000

Heli-Coil

Location

Loc Qty

Loc Code

ST305

99

108170

78

108244

21

NAS1149F0932P

Purchased

No

Each

619.0000

WASHER

Location

Loc Qty

Loc Code

ST275

619

18057

619

PTC

8/5/08/09

8/5/08/09

8/5/08/09

8/5/08/09

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Shop Packet Print

Page 2

| W/O: | | WORK ORDER CHANGES | | | | | |
|----------|------|------------------------------------------------------------------------------------------------------------|--------------------|----------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| 10.08.10 | | PERMANENT CHG. T1P0 ON B.O.M. CHANGE NAS1149033P to NAS11490663R. 119185 (20) A/N 96 C616 | <i>[Signature]</i> | 10/08/10 | 2 | 10.08.10 asl atz | S 10/04/10 |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

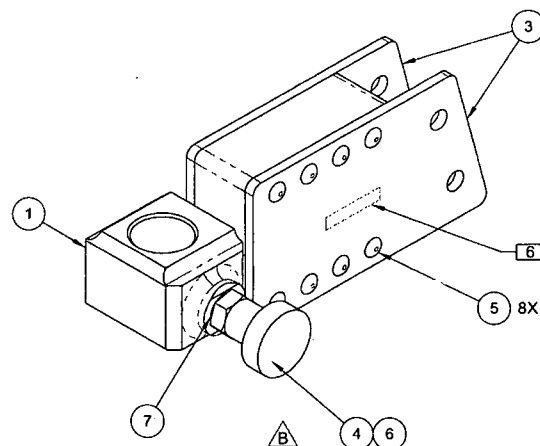
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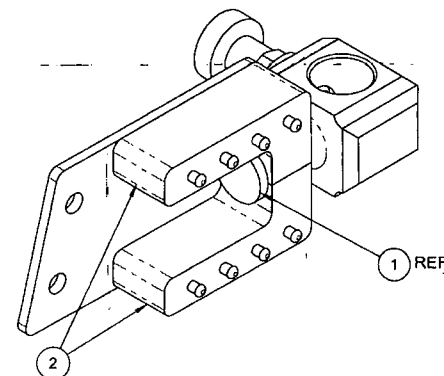
| ITEM | QTY -041 | P/N | DESCRIPTION |
|------|-------------|--------------|-----------------------|
| | X | D3912-041 | EYEBOLT RECEIVER ASSY |
| 1 | 1 | D3912-1 | EYEBOLT |
| 2 | 2 | D3912-3 | EYEBOLT BLOCK |
| 3 | 2 | D3912-5 | EYEBOLT PLATE |
| 4 | 1 | D3801-1 | SPRING PLUNGER |
| 5 | 8 | MS20915-4M20 | RIVET |
| 6 | 1 | MS21209-F615 | HELICAL |
| 7 | 1 | NAS1149F0002 | WASHER |

0663R

10-08-10



#61077



SUPPLEMENTAL ISO VIEW
(EYEBOLT PLATE REMOVED
TO SHOW INTERIOR FEATURES)

D3912-041 EYEBOLT RECEIVER ASSY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N D3912-041 USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT -041: 1.58 lbs

RELEASED
2010-07-16

| | | | |
|------------|---------------------------------------------------------------------------------------------------------------------------------------------------|-----|----------|
| B | D3801-1 WAS D3810-1 SPRING PLUNGER; D4028-041 RMV; MS21209-F615 WAS MS21209-C610 HELICAL; (1) WASHER; NAS1149C0663R ADDED; BOSS ADDED TO D3912-1. | JPH | 10.06.28 |
| A | NEW ISSUE | JPH | 10.03.04 |
| REV. | DESCRIPTION | BY | DATE |
| DESIGN | DESIGN | | |
| DRAWN | DRAWN | | |
| CHECKED | CHECKED | | |
| MFG. APPR. | MFG. APPR. | | |
| APPROVED | APPROVED | | |
| DE APPR. | DE APPR. | | |
| DATE | 10.06.28 | | |

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D3912** REV. B
SHEET 1 OF 3
TITLE **EYEBOLT RECEIVER ASSY** SCALE NTS

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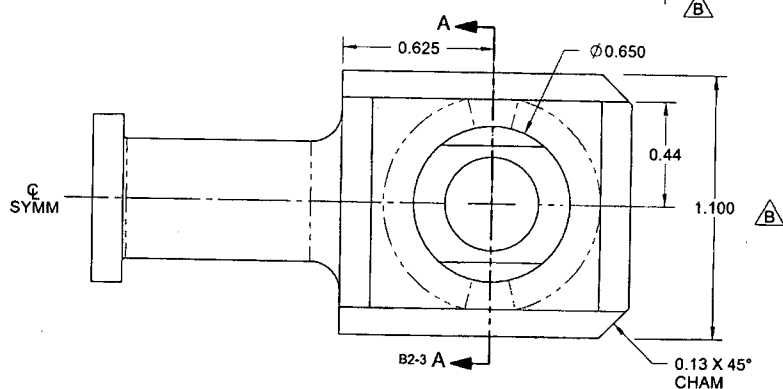
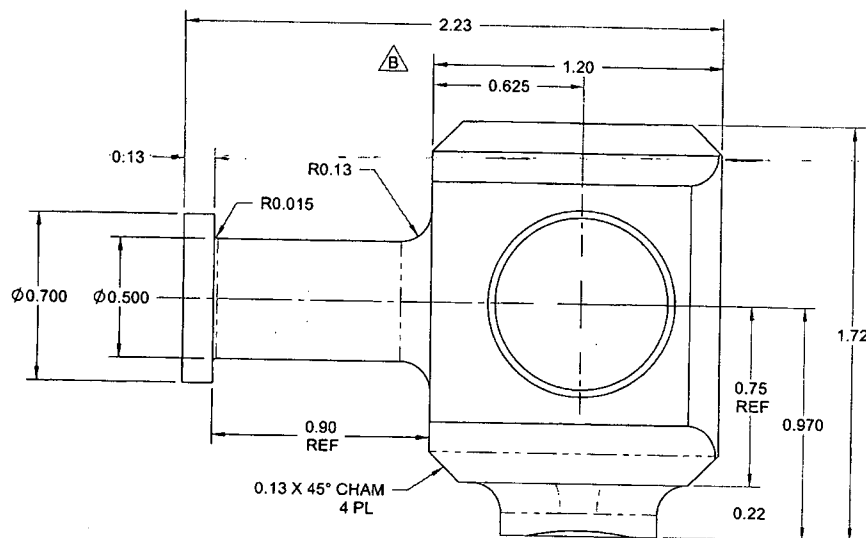
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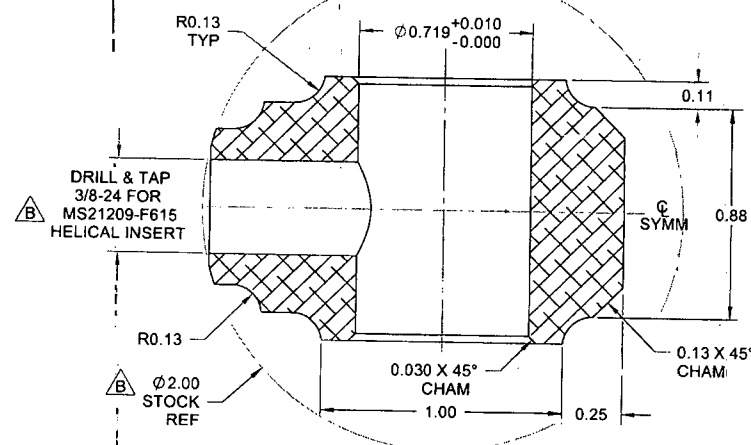
NOTE: Date & initial all entries



D3912-1 EYEBOLT

NOTES:

- 1) MATERIAL: 303/304/316 STAINLESS STEEL ROUND BAR, PER ASTM A276 OR ASTM A582
REF DART SPEC M303R OR M304R
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ID AT ASSEMBLY
- 7) WEIGHT: 0.45 lbs



SECTION A-A B6-3

RELEASED
2010-07-16

| | | | |
|--------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|----------|----------------------------------------|--------------|
| DESIGN | AS | DART AEROSPACE LTD | |
| DRAWN | JS | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | JS | DRAWING NO. | REV. B |
| MFG. APPR. | JS | D3912 | SHEET 2 OF 3 |
| APPROVED | JS | TITLE | SCALE |
| DE APPR. | JS | EYEBOLT RECEIVER ASSY | NTS |
| DATE | 10.06.28 | COPYRIGHT © 2010 BY DART AEROSPACE LTD | |
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NOTE: Date & initial all entries

[illegible]

NOTES:

- NOTES
- 1) MATERIAL -3: 303/304/316 STAINLESS STEEL BAR, PER ASTM A276
REF DART SPEC M303B OR M304B
- 5: 303/304/316 STAINLESS STEEL SHEET ANNEALED 2B, 0.125 THK
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME 5A240
REF DART SPEC M303S11GA OR M304S11GA

- 2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: ID AT ASSEMBLY
7) WEIGHT -3: 0.30 lbs
 -5: 0.24 lbs

RELEASE
2010-07-16

| | | | |
|------------|--------------------|-----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--------------|
| DESIGN | <i>AKS</i> | DART AEROSPACE LTD | |
| DRAWN | <i>[Signature]</i> | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | <i>[Signature]</i> | DRAWING NO. | REV. B |
| MFG. APPR. | <i>[Signature]</i> | D3912 | SHEET 3 OF 3 |
| APPROVED | <i>[Signature]</i> | TITLE | SCALE |
| DE APPR. | <i>[Signature]</i> | EYEBOLT RECEIVER ASSY | NTS |
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